

IN THE SPECIFICATION:

Please amend the paragraph beginning at line 9, page 9, as follows:

The movement of the four punches 10, 12, 20 and 22 (Figures 1 and 2) are actuated by hydraulic cylinders 120, 122, 124 and 126 which are operable by means of hydraulic servos 121, 123, 125 and 127, respectively, in response to data or signals from a second multi access controller 130. The second multi access controller 130 is operably connected to the LAN 101 and is effective in controlling eight parameters i.e., four position and four pressure sensors, one each for each of the punches 10, 12, 20 and 22. The second multi access controller 130 receives data corresponding to the positions of the cylinders or pressures on each of the punches from Tempasonic digital position feedback devices 132, 134, 136 and 138, respectively, and pressure from pressure transducers 133, 135, 137, 139 ±30, 133', 135', 137', ±30, and ±30 ± 139'. Two pressure transducers are provided for each of the four cylinders with one on each side of the pistons.